

Touch up vs req'd

Work Order ID-51884

Tuesday, September 08, 2009 3:15:40 PM

Page 1

Item ID: D350-748-201

Revision ID: D

Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009 Start Qty: 1.00

Required Date: 9/29/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 09-9-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-201

CHG001

8/10/13

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

IX MB 10-01-14

120

0.00



QC15- Crosstube Dimensional Check

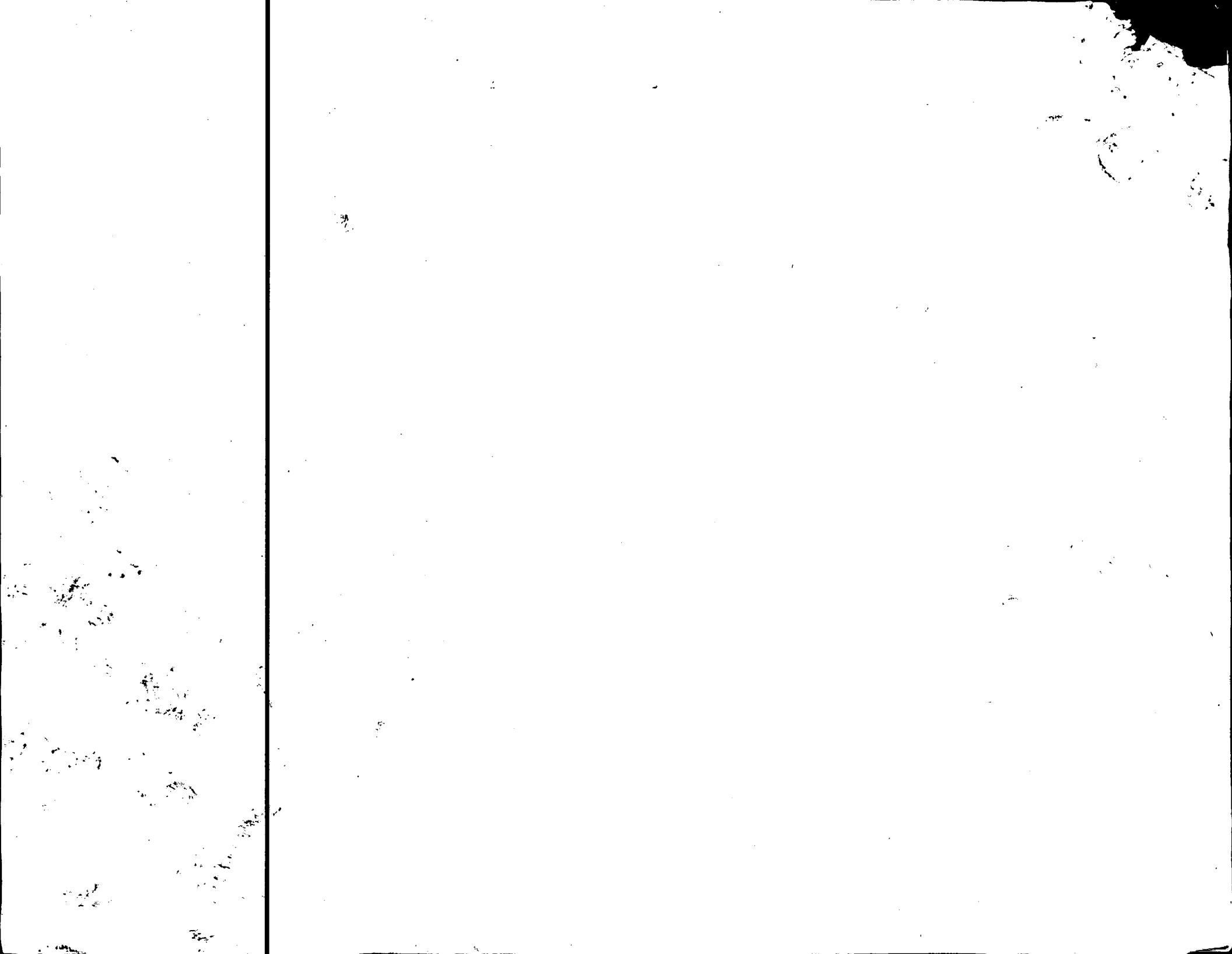
QC

Memo

0.00

Quality Control

CP 10-01-14



Work Order ID 51884

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Item ID: D350-748-201

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube
Batch: 109956

MB 10-01-14
C.M. 10-01-27
AWM 10-1-28

140

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Batch # 109956
Memo

0.00

5/12/12

(10)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 11282
Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

BS 10-2-01

160

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Per 43/1

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

MA 10 04 20 (1)

Work Order ID 51884

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Item ID: D350-748-201

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Reference:

Cust Item ID:






Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  SprayPaint Spray Painting	SprayPaint Memo 1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2	0.00 0.00					10	04	20 ①
190  QC Quality Control	QC14- Inspect Spray Paint Memo Then, Wrap in plastic bag to protect from scratches	0.00 0.00					25	10-04-21	
200  Crosstubes Crosstubes	Crosstubes Memo 1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS	0.00 0.00					10	04	21 ①

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Required Date: 9/29/2009 Req'd Qty: 1.00



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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/10/04/21						
220 Packaging Packaging	Pick Kit Memo	0.00 0.00					10.4.28		
230 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	8/10/05/13						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: NCR 10-026 Fault Category: Y-tubes NCR: Yes No DQA: [Signature] Date: 100512
 Resolution: AC Disposition: [Signature] QA: N/C Closed Date: 10/05/17

NCR: 51884		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-05-11		NCR 10-026 - TO verify that the tubes are good, per the cracking issue on the above NCR	CP 10.05.12 QSI 042	load test per Dands email ref NCR 10-026	[Signature] 100511	CP 10.05.12 QSI 042	[Signature] 10/05/12	[Signature] 100512
			CP 10.05.12 QSI 042	backup as necessary replace abrasion strip if necessary	mm 10.05.12	[Signature] 10/05/13	[Signature] 10/05/12	[Signature] 100512

NOTE: Date & initial all entries

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 27, 2010 3:40 PM
To: 'Mike Petsche'
Cc: 'Bill Beckett'; 'L Lacelle'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com
Subject: 350 crosstubes

Mike,

I discussed the 350 crosstube load testing with Bill a little while ago and this plan makes sense to him.

So, my recommendation to clear these crosstubes is to load the fwd crosstubes to 3500 lb and the aft crosstubes to 3000 lb in the deflection test rig and document on the work orders that this test has been completed. Hold max load for 1 minute. Per TP-D350-748-2, these loads represent the maximum load on these crosstubes at gross weight and are below the yield point of the material. I would like to request that Chris Provencal witness these tests and sign off the work orders based on his experience with Dart landing gears. My feeling is that if there is a problem with the parts, it will manifest itself during this load test. I, for one, would feel a lot more confident in testing each crosstube in this manner than relying totally on what Exova has to say. I think it would be very difficult to reach a conclusion on the whole batch on the basis of cracks in two parts from the batch.

I believe that we can accomplish this before next Friday, which also gives us time to hear what Exova has to say in case it has an impact on our decision. So far, what I have seen from Exova shows me that there are fluctuations in the heat treating but the tubes are heat treated to our specification.

For this reason, I believe we should tell DHS that it looks like we will be able to start shipping 350 crosstubes by May 7th pending a successful Engineering test of the material.

David.

5/11/10

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

240



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD350-748-201

Location:

PPP Rev: 13

0.00

0.00

0.00

0.00

250



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

POSITIVE RECALL

EFFECTIVE 10/19

AUTH 10-05-13

RELEASED 10-05-13

DATE 10-05-13

NOV 10-026

see cfl 2601 cf 10-05-17
sign off

10/05/17

MF

10-5-14

10/10/13

Picklist Print

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Work Order ID: 51884



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D350-748-201RevD		Manufactured	No			110	Each	4.0000	1.0000			

2411TRNREV D



Crosstube Turning Detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

47167

47170

47171

47172

B48606

1

1

1

1

200

Each

8,753.000 1.0000

DD 10-1-13

ALS4-1032-225

Purchased

No



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

107441

110768

8753

16

8737

ml 10.04.21

Picklist Print

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Work Order ID: 51884



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No			200	Each	2,309.000	1.0000			
Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2309

105442

95

109059

2

109840

23

110985

202

111279

13

111668

70

112314

1000

112369

904

ml 10 oct 21

D2856-400RevA

Manufactured

No

200

f

332.4577 1.2432



Abraison Strip

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

122.8077

42437

44.93

46543

77.8777

Main Warehouse

ST403

209.65

50593

209.65

ml 10 oct 21

56626

1- cut as per dwg D2856

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Parent Item: D350-748-201RevD

Parent Item Name: Crosstube Installation, High Aft



Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3502-1RevB		Manufactured	No			200	Each	43.0000	2.0000			
												
Support												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	5	
41603	2	
42968	2	
47120	1	

Main Warehouse

ST168	38	
50287	38	

m/ 10.04.21

MS21920-20

Purchased

No

200

Each

117.3000

2.0000



Clamp (per MIL-DTL-8783C)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	117.3	
103478	2	
106484	12	
109269	9.3	
110536	10	
111281	34	
112307	50	

m/ 10 04 21

B# 112793

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Work Order ID: 51884



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-10

Purchased

No

200

Each

37.0000

1.0000



Screw

B# 112794

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37

111425

37

220

Each

142.0000 8.0000



M 10-04-21

AN4-41A

Purchased

No



Bolt

M 1110731 10-4-285

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

142

105940

4

110363

16

110731

50

111424

50

112082

22

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Work Order ID: 51884



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-6A		Purchased	No			220	Each	814.0000	16.0000			
--------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Bolt

M112829 10-4-28 SF

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 814

102602 3

105810 15

107534 1

109545 2

110399 27

111279 466

112314 300

AN5-32A

Purchased

No

220

Each

79.0000

4.0000



Bolt

M113121 10-4-28 SF

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 79

106242 3

106519 4

110363 17

111916 5

112082 50

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Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416		Purchased	No			220	Each	8,758.000	32.0000			
------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Washer
NAS1149204632



M113706 10-4-285

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	8758	
102929	2	
105906	4	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	115	
111916	2620	
112314	4887	
16941	0	

Picklist Print

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Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516

Purchased

No

220

Each

1,209.000

8.0000



M113706 15-4-285

Washer

NA5114900563

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1209

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

359

112314

500

D3500-1RevC

Manufactured

No

220

Each

17.0000

4.0000



555605 10-4-285

Saddle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

47119

12

47350

5

53792
52326 (3x)

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3501-1RevA

Manufactured

No

220

Each

423.0000

16.0000

~~3~~ 13



~~1345402~~ 45918

Bushing

10-4-285

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

423

45402

19

45918

200

48268

204

3
B

MS21042L4

Purchased

No

220

Each

8,308.000

24.0000



1
M114108 10-4-285

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8308

107499

5

110507

266

111827

5996

112314

2000

15924

0

8182

41

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			220	Each	1,337.000	4.0000			

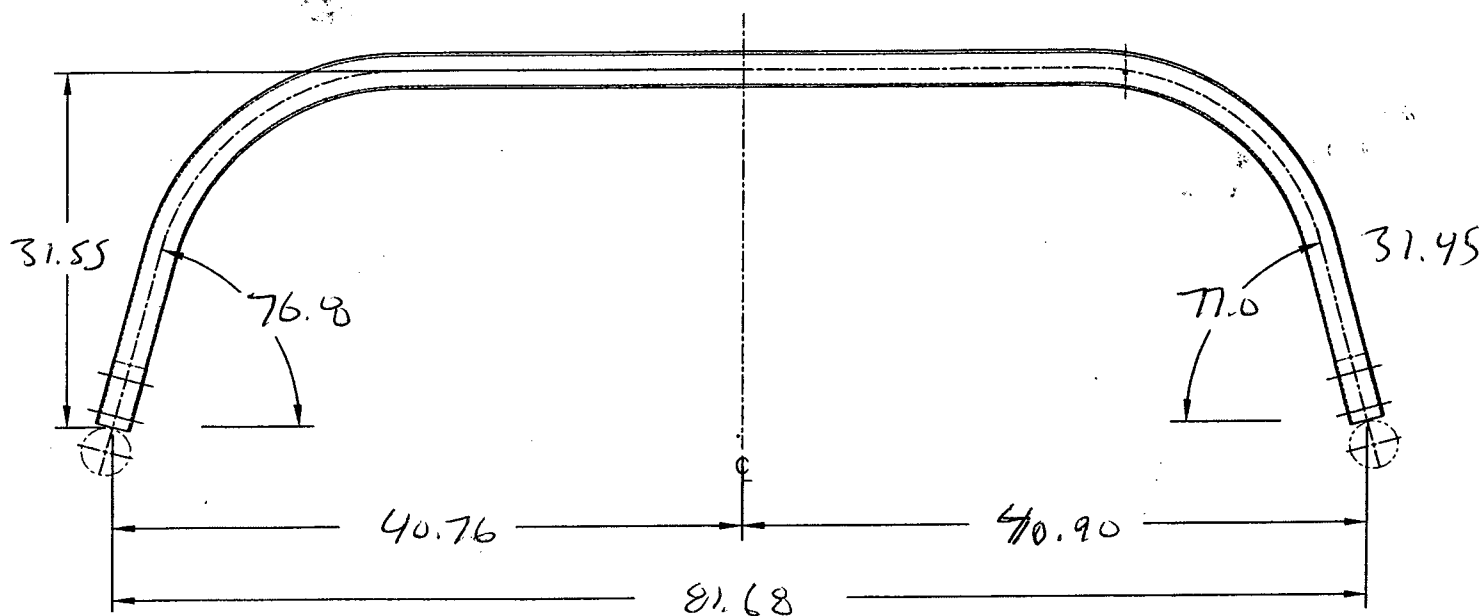
5 Nut

M113537 10-4-08 5

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1337	
110382	10	
111636	327	
112314	1000	

DART AEROSPACE LTD		Work Order:	51884
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1	

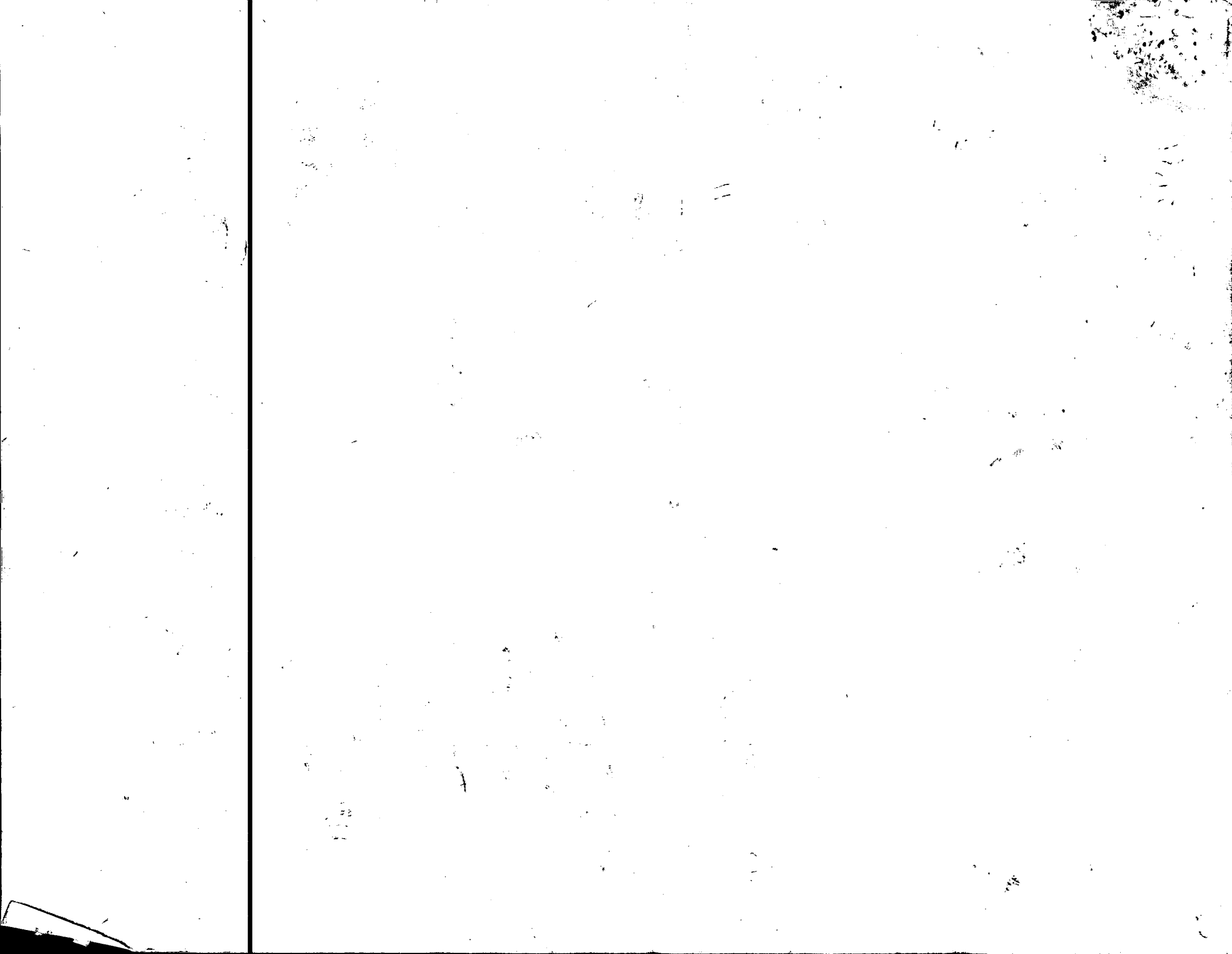
Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
Tube is high and narrow on one side.
OK of 10.02.14
Twist = 0.031"

QC15 Inspection	of 10.01.14
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	





RELEASED

06.10.31

DESIGN	92	DRAWN BY	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	///	APPROVED	///	DRAWING NO.	REV. D
				D350-748-241	SHEET 1 OF 3
DATE				TITLE	SCALE
06.10.31				CROSSTUBE (AS 350/355 HI AFT)	NTS
A	06.03.31		NEW ISSUE		
B	06.06.30		ADD D6018-125 & PRIME AND PAINT		
C	06.08.14		ADD CAD PLATING		
D	06.10.31		MAG. PARTICLE AND CAD PLATE AS MFD.		

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

09.02.05
PER PCR #09-001

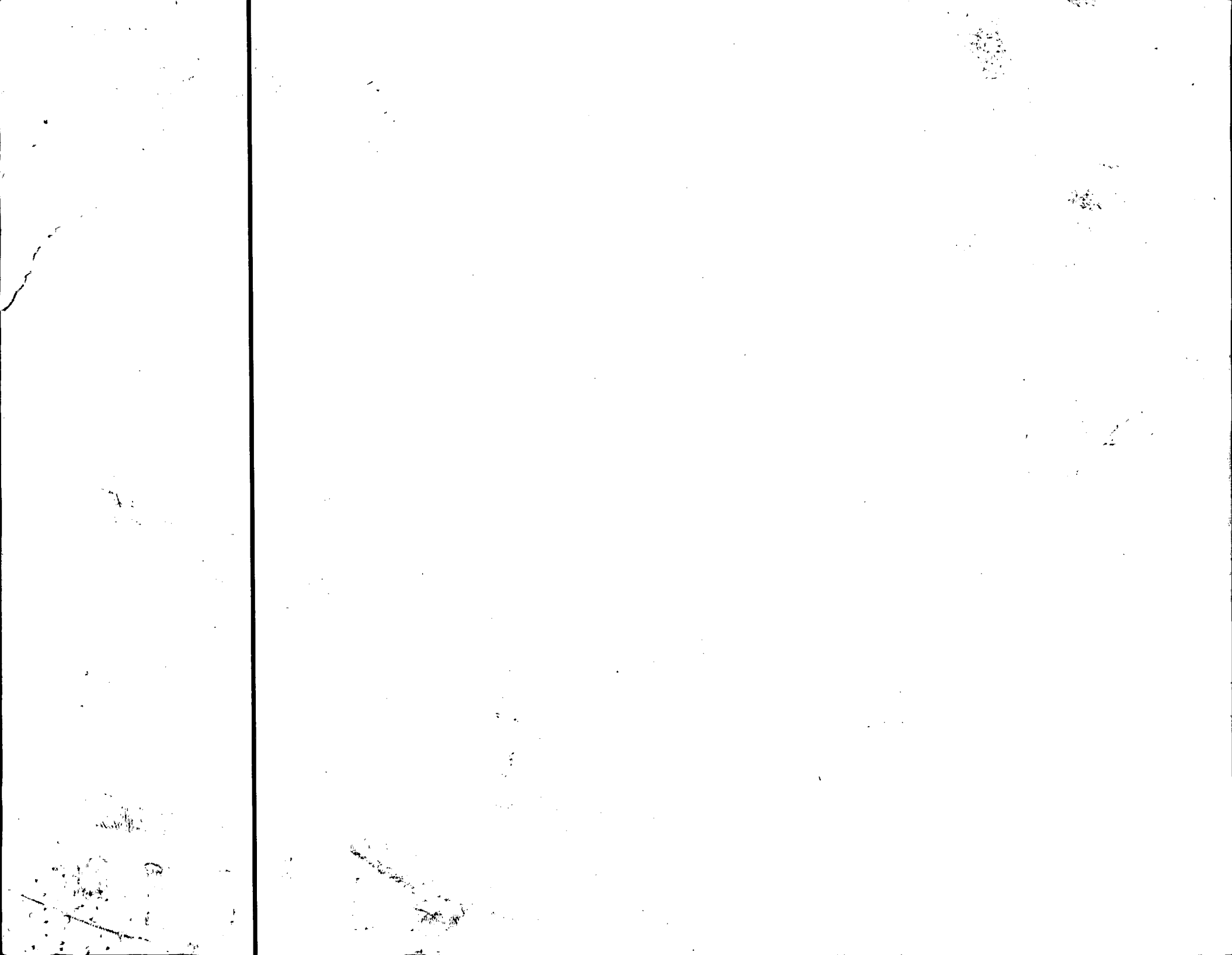
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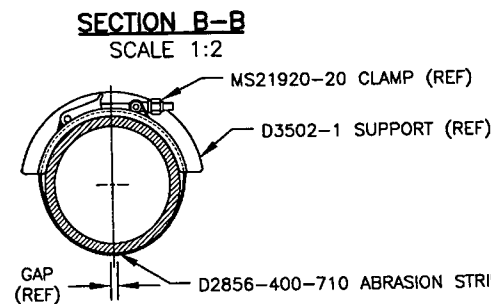
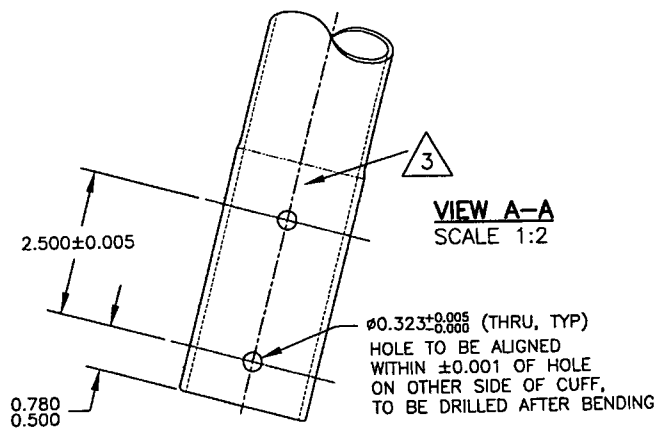
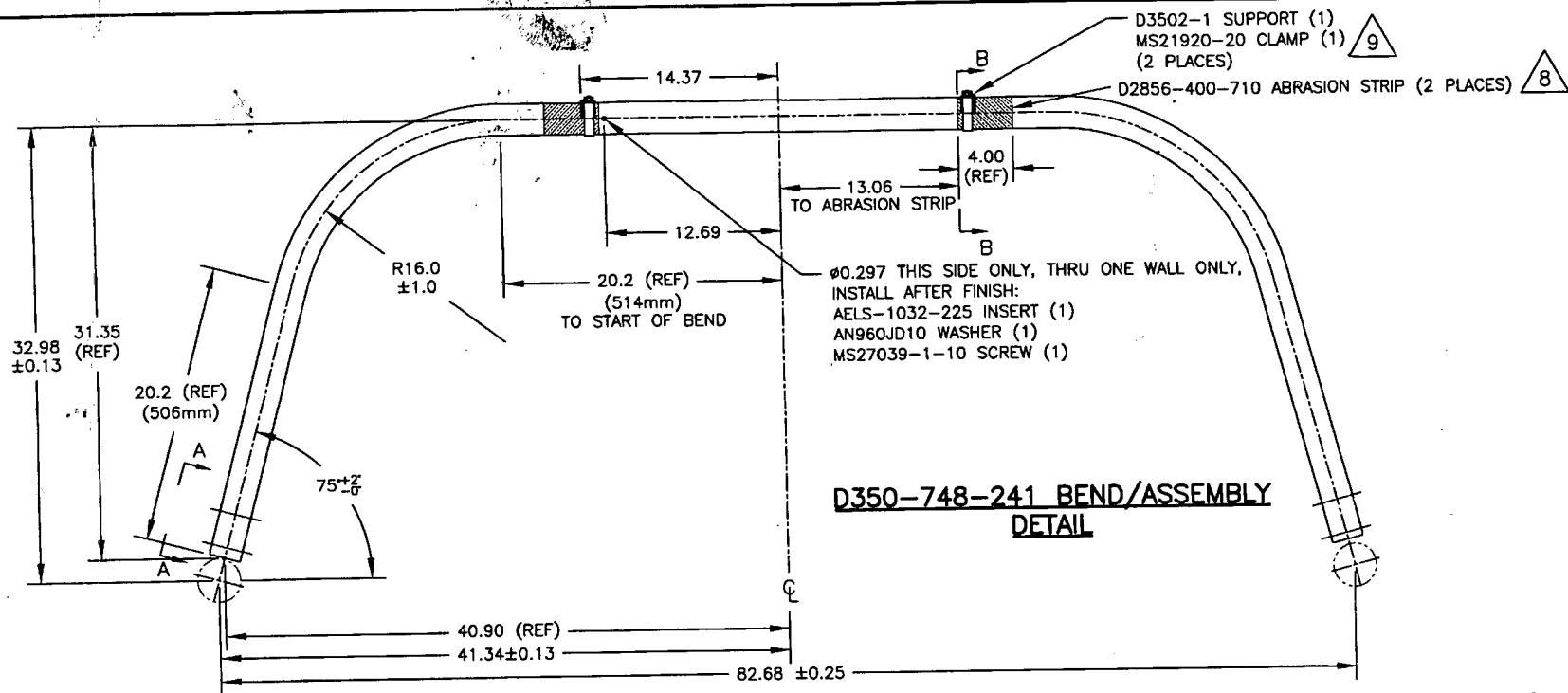
UNDER REVIEW

07.02.16
OK 07.10.22

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UNDER REVIEW

09.02.05

UNDER REVIEW

07.02.06

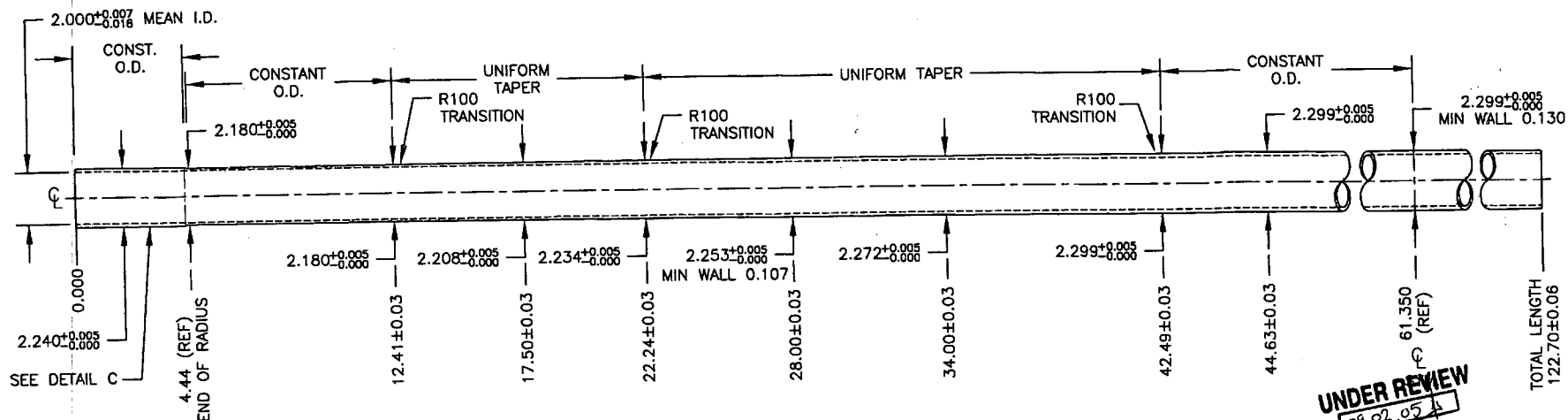
OK 10.10.22

RELEASED

06.10.31

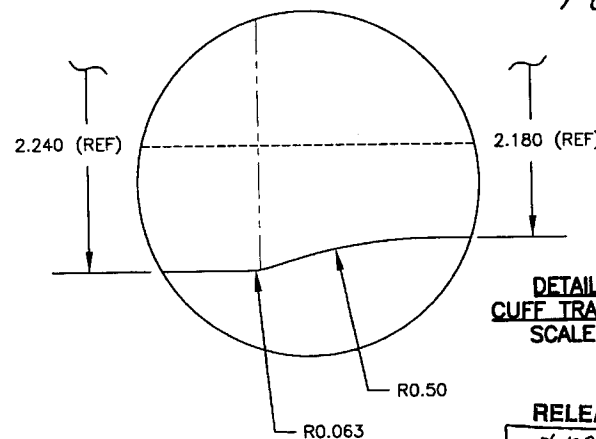
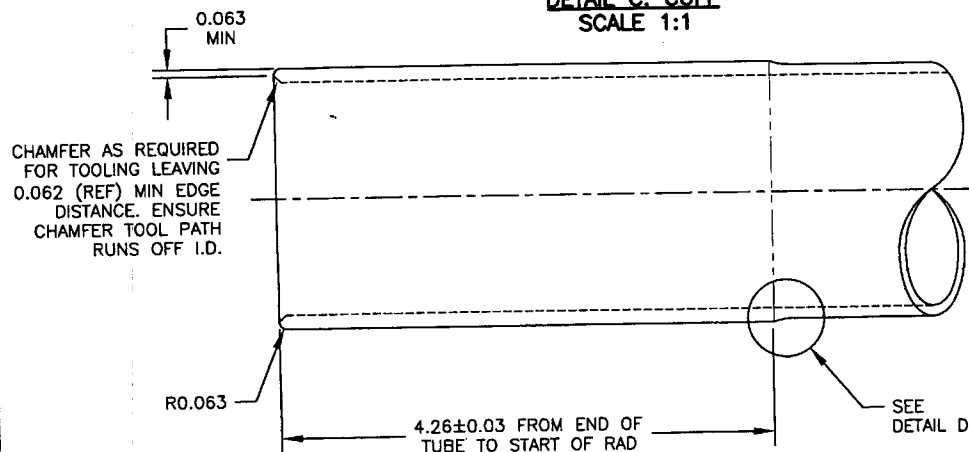
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		DATE	06.10.31			D350-748-241	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (AS 350/355 HI AFT)	1:8

51884



D350-748-241 MACHINING DETAIL

DETAIL C: CUFF SCALE 1:1



DETAIL D: CUFF TRANSITION SCALE 9:1

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DESIGN 07	DRAWN BY 07	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	

5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Feb-22-2010

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 93267

INVOICE #: 48326

**CONTRACT OR
PURCHASE ORDER #** 513885

DESCRIPTION: SKID

QTY 1

P/N # D350-748-201

S/N # B51884

STRESS RELIEF BAKED @ 375 DEG. FOR 5 HRS. BAKE HEAT
CHART #10-116. MPI INSPECTED IAW ASTM-E-1444. CADMIUM
PLATED IAW AMS-QQ-P-416B, TYPE 2 YELLOW, CLASS 1. BAKE
HEAT CHART #10-169.

CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.

Approved Inspector:

